

Spur
Work Order ID 153190 **3**

Wednesday, November 09, 2016 12:45:00 P

153190

Page 1

Item ID: 647.7501

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 11/10/2016 Start Qty: ~~4.00~~

Required Date: 11/15/2016 Req'd Qty: 4.00

Reference

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approval:

Process Plan: VS

Date: 11/11/9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7500	A								

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4 NOV 23 2016

DAS
6
9-89

120

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 135385
exp. date: 04/18

1X 11/12/16 DAS 36 9-89

130

130

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

Quality Control

① 11-12-19

DAS
9
9-89

Work Order ID 153190

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153190

Page 2

Item ID: 647.7501 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 11/10/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/15/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence II/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location CC/Kool Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.01				1X		SP16-12-19.	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							

DAS
21
9-89

DEC 20 2016

mf
16-12-19

Picklist Print

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Page 1

Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

153190

647 7501

Start Date: 11/10/2016

Start Qty: 4.00

Required Date: 11/15/2016

Required Qty: 4.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* Center Plate, Lower		Manufactured	No				Each	9.0000		4			
									**				
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						CCK114	9						
						147215	9						
647.7810 *647 7810* Bracket A		Manufactured	No				Each	3.0000		4			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						CCK077A	3						
						146724	3						
647.7811 *647 7811* Bracket B		Manufactured	No				Each	3.0000		4			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						CCK077A	3						
						146725	3						
646.3015 *646 3015* Blade		Manufactured	No				Each	1.0000		8			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						cck103	1						
						147542	1						

NOV 23 2016 10:39

B 147216

DAS 30 9-89

NOV 23 2016

DAS 6 9-89

**

B 147217

DAS 30 9-89

NOV 23 2016

DAS 6 9-89

**

B 150 682

6

NOV 23 2016 10:39

DAS 6 9-89

Picklist Print

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Page 2

Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutter Assembly

153190

647 7501

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

647.7601

Manufactured No

Each 3.0000

647 7601

Lower Deflector Assembly

**

137076 NOV 23 2016

DAS 6

Location

Loc Qty

Loc Code

cck065

3

148222

3

Each

3.0000

3

**

DAS 30 NOV 23 2016

DAS 6

647.7815

Manufactured No

647 7815

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138151

3

Each

3.0000

3

**

NOV 23 2016

DAS 6

647.7814

Manufactured No

647 7814

Fwd Bracket

Location

Loc Qty

Loc Code

CCK114

3

138152

3

Each

3.0000

3

**

NOV 23 2016

DAS 6

647.7816

Manufactured No

647 7816

Aft Bracket

Location

Loc Qty

Loc Code

CCK114

3

138240

3

Each

4.0000

3

**

NOV 23 2016

DAS 6

647.7817

Manufactured No

647 7817

Aft Bracket

Location

Loc Qty

Loc Code

CCK115

4

138364

4

4

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 153190

Parent Item: 647.7501

Parent Item Name: Lower Cutler Assembly

153190

647 7501

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

NAS1149FN832P

Purchased

No

Each

1,519.000

104

NAS1149FN832P

Washer

**

16/12/19
DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1389

M133769

89

M135058

1300

ST263

130

M135603

130

Each

0.0000

12

**

135767 NOV 23 2016

MS21042-3

MS21042L3

Purchased

No

MS21042-3

Nut

MS21042-08

MS21042L08

Purchased

No

MS21042-08

USE MS21042L08

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

Each

2,822.000

24

**

NOV 23 2016

Location

Loc Qty

Loc Code

GA

276

m133709

276

ST260a

2000

m135948

2000

ST262

546

m135544

546

NOV 23 2016

DAS

6

9-89

Picklist Print

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Page 4

Work Order ID: 153190

153190

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 11/10/2016

Required Date: 11/15/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-19

Purchased

No

Each

315.0000

28

MS27039-08-19

Screw

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

28

MS27039-1-19

Purchased

No

Each

123.0000

12

MS27039-1-19

Screw

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

43

m135774

43

12

MS27039-08-24

Purchased

No

Each

281.0000

24

MS27039-08-24

Screw (MS27039-0824)

**

DAS

6

9-89

NOV 23 2016

Location

Loc Qty

Loc Code

GA

279

124326

279

ST277

2

125654

2

2

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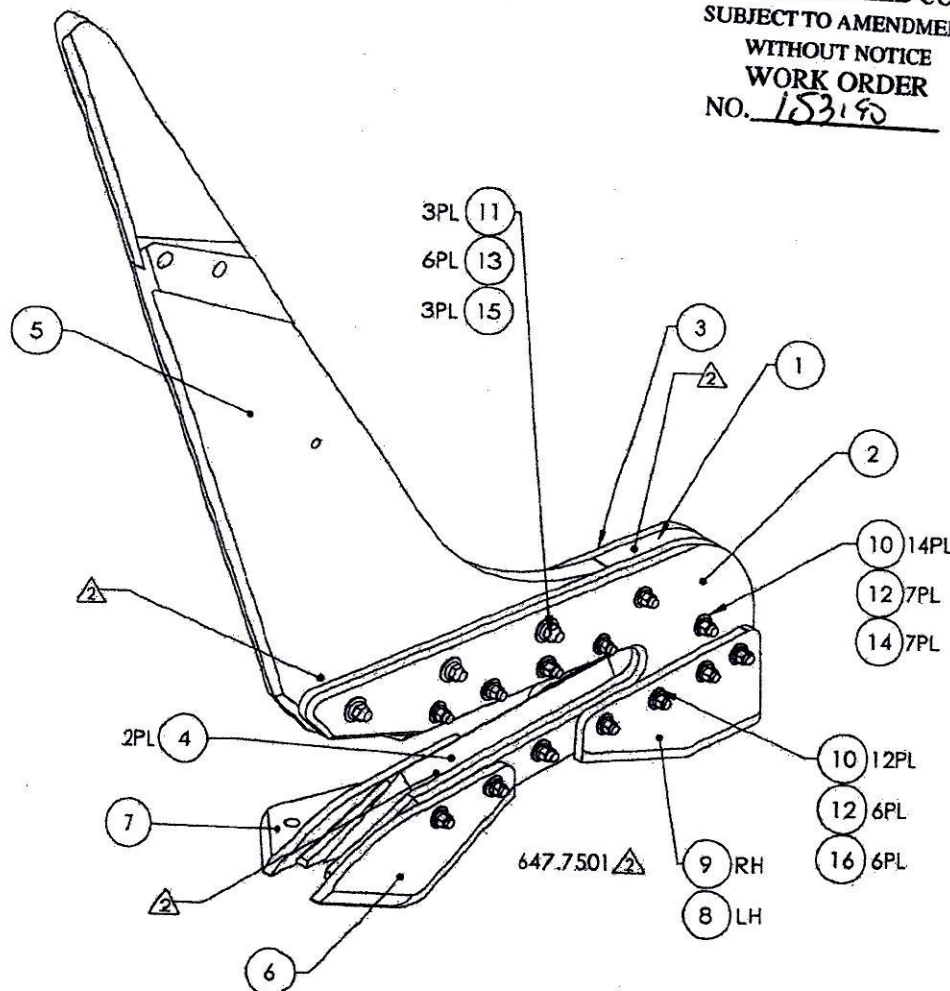
NOTES:

1. IDENTIFY IAW MPP-120

△ APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153190

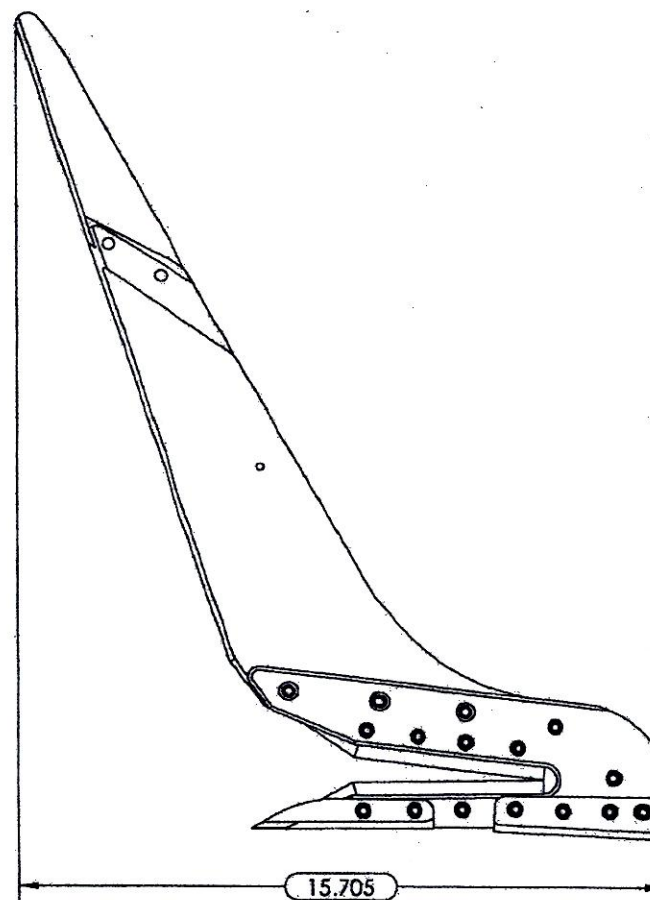
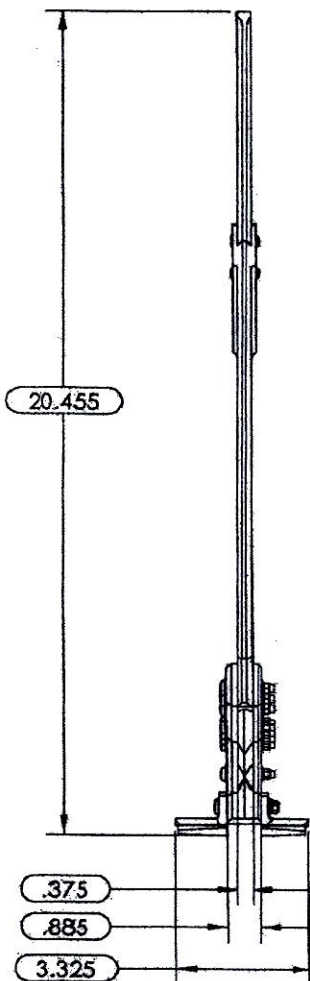
16/11/9



A/R	17	601.2045	RTV, LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
△	1	647.7501	LOWER CUTTER ASSY		△
7501	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		APICAL INDUSTRIES	
647.7300		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
ORIGINAL DATE		LOWER CUTTER ASSY	
DRAWN BY		REV. A	
CHECKED BY		SCALE NONE	
DRAWING APPROVAL		SHEET 1 OF 2	
DESIGNED BY			
DATE OF REVISION			
REVISIONS			
1. DIMENSIONS SPECIFIED			
2. DIMENSIONS ARE IN INCHES			
3. DIMENSIONS ARE IN MILLIMETERS			
4. DIMENSIONS ARE IN FEET			
5. DIMENSIONS ARE IN METERS			

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ORIGINAL DATE	11-24-89	APICAL INDUSTRIES	
DRAWN BY	CHIEFER	2608 TEMPLE HEIGHTS DR.	
A. CHIEF	P. WARD	OCEANSIDE, CA. 92056-3512 (760)724-5300	
DESIGNED BY	APPROVAL	LOWER CUTTER ASSY	
DATE	11-24-89	SCALE NONE	
CONSTRUCTION		SHEET 2 OF 3	
VALUES OTHERWISE SPECIFIED		DWG. NO. 647.7500	
TOLERANCES ARE IN INCHES		REV. A	
1 PLACE DECIMALS .1			
2 PLACE DECIMALS .01			
3 PLACE DECIMALS .001			
ANGLES .5°			